

Work Order ID 134290

134290

Page 1

Wednesday, July 08, 2015 3:08:17 PM

Item ID: D2896-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 7/07/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 7/07/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: JUL 09 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2896	C								

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA167

Folio Rev: AA

Dwg Rev: C

Debur

****Program Batch #*****

0.00

0.03

6

6

JFC 2015-09-02

110

110

QC

Quality Control

QC1- Inspection performed by CMM

Memo

0.00

0.00

6

6

JFC 2015-09-02

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 134290

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134290

Page 2

Item ID: D2896-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 7/07/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 7/07/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 08 9-89
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>L651</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	LOCATION 1005								15-9-15
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

MCS SEP 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, July 08, 2015 3:08:16 PM

Page 1

Work Order ID: 134290

134290

Parent Item: D2896-1

D2896-1

Parent Item Name: Support

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP: B02.11.26Reformat; Added P/O; Added mask holeKJ

IPP Rev:C As per Rev B 07-04-16 JLM

IPP D 08.03.19 Re-format EC verified by DD

IPP REV:E

11.10.03 ASPER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK080		Manufactured	No			100	Each	3.0000	0.5	3			

DSK080

D2896-1 Turning Detail

Location

Loc Qty

Loc Code

MAT060

3

104458

3

3 JKL 2015-07-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

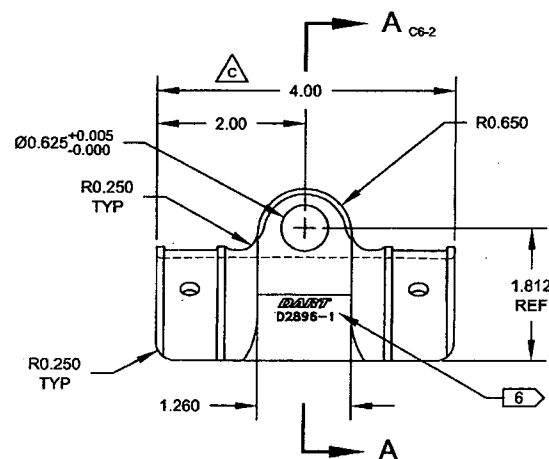
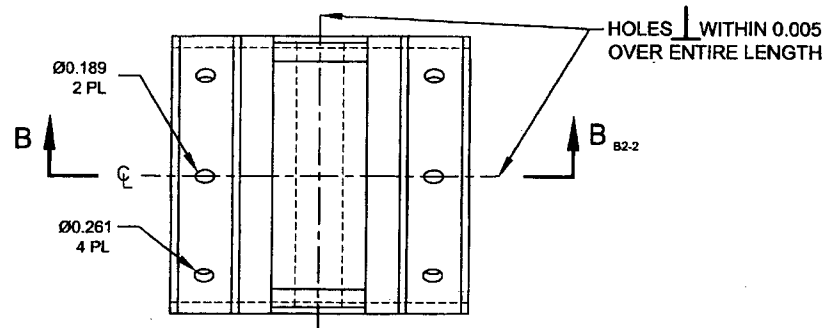
DART AEROSPACE LTD		Work Order: 134290
Description: Support		Part Number: D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions					
				1	2	3	4	5	6
HAAS Section									
AA	2.152	2.172		2.161	2.167	2.165	2.165	2.165	2.165
AB	2.340	2.360		2.345	2.346	2.352	2.352	2.353	2.353
AC	3.550	3.560		3.556	3.556	3.554	3.554	3.554	3.554
AD	3.770	3.790		3.779	3.779	3.780	3.780	3.778	3.780
AE	0.065 x 0.315	0.085 x 0.335		0.075 x 0.325	0.075 x 0.325	0.075 x 0.325	0.075 x 0.325	0.075 x 0.325	0.075 x 0.325
AF	1.42	1.48		1.448	1.448	1.449	1.449	1.449	1.449
AG	0.833	0.853		0.8373	0.8373	0.839	0.839	0.8435	0.8435
AH	0.240	0.260		0.250	0.250	0.250	0.250	0.250	0.250
AI	0.261	0.266		0.262	0.262	0.2625	0.2625	0.2625	0.2625
AJ	0.189	0.194		0.1895	0.1895	0.189	0.189	0.189	0.189
AK	1.970	2.030		1.996	2.002	1.998	2.000	2.000	2.000
AL	0.625	0.630		0.625	0.625	0.626	0.626	0.626	0.626
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946		0.935	0.935	0.936	0.938	0.9385	0.936
AP									
AQ									
AR	⊥			0.0025	0.003	0.004	0.001	0.0015	0.0015
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"									
Accept/Reject									

Measured by: JFC	Date: 2015-09-03
Audited by: DAS	Date: 15/09/14
Preliminary Approval: 08	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	



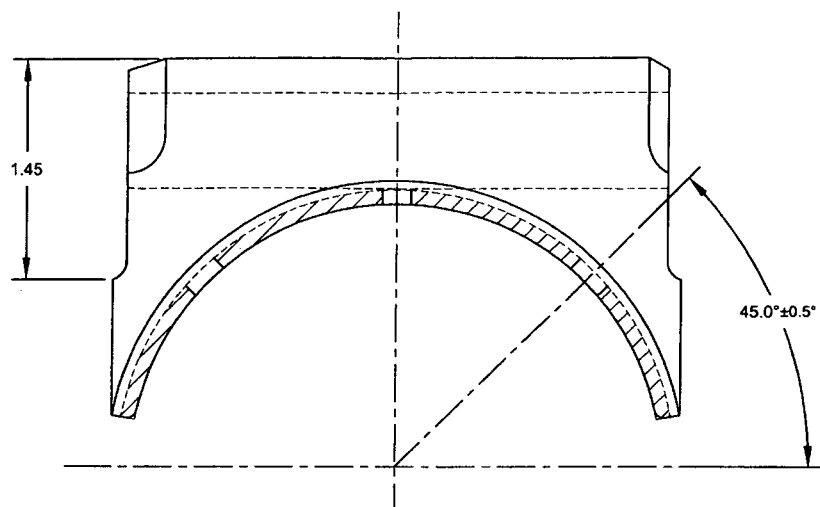
NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
PER ASTM A564 OR AMS 5643 OR AISI 630
MIN UTS = 170 KSI (38 HRc)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP PER DART QSI 044 6.3
- 7) WEIGHT: 1.76 lbs

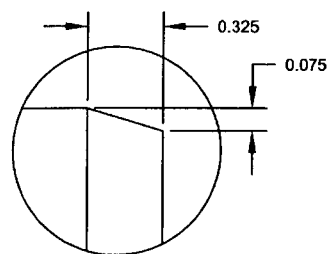
RELEASED
2011-09-29

C	RMV FINISH & UPDATE MAT'L SPEC (A8-1), 2.00 WAS 2.000, 4.00 WAS 4.000 (C4-1), REFORMAT DWG	CP	11.09.07
B	INCORP. A1-A4, FINISHING NOTES	PH	07.03.19
A	NEW ISSUE	CP	01.10.19

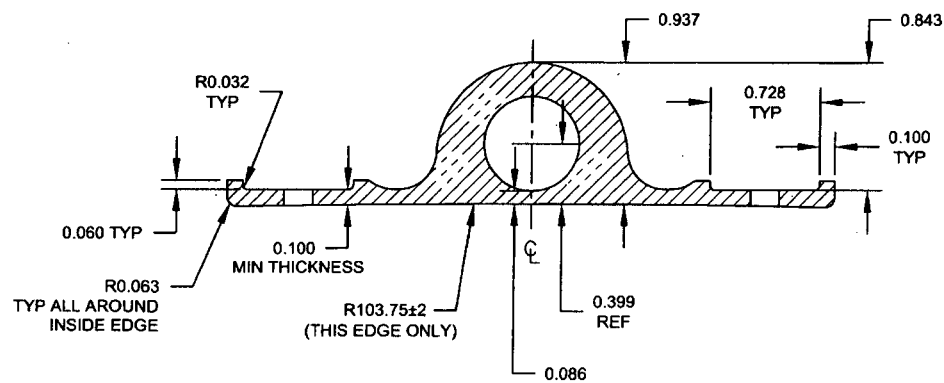
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D2896	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	N°
DATE	11.09.07	COPYRIGHT © 2001 BY DART AEROSPACE LTD DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	



SECTION A-A C3-1
TOOLING HOLE DETAIL
SCALE 2X



DETAIL C C6-1
SCALE 4X



SECTION B-B D3-1
SCALE 2X

RELEASED
2011-09-29

DESIGN	gp	DART AEROSPACE LTD	
DRAWN	gp	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	[Signature]	D2896	SHEET 2 OF 2
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	SUPPORT	NTS
DATE	11.09.07	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	